

Date: Tuesday, 9/26/2006 2:43:18 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : CLAMP
<b>Job Number</b> : 28732	
<b>Estimate Number</b> : 10267	
<b>P.O. Number</b> : NIA	<b>Part Number</b> : D2438
<b>This Issue</b> : 9/26/2006 <b>S.O. No.</b> : NIA	<b>Drawing Number</b> : D2438 REV. C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : NIA <b>Type</b> : PURCHASED PARTS	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 28345	<b>Material</b> : NIA
<b>Written By</b> : <u>[Signature]</u>	<b>Due Date</b> : 10/10/2006 <b>Qty:</b> 200 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>[Signature]</u>	
<b>Comment</b> : Est: E 05.06.28 Bending removed KJ/JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	PG	PURCHASING
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**Comment:** PURCHASINGIssue P/O: 2135

Laser cut as per Dwg D2438

Material release note is required

U 06.09.27

2.0	D2438B	Clamp
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 200.0000 Each(s)  
 CLAMP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Recieve &amp; Inspect for Transit Damage

Ensure Material Release Note is attached

06/11/14 (200)

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

Inspect dimensions as per Dwg D2438  
 (6.786" center to center)

06.11.15 QSP019

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Tumble &amp; Deburr any rough edges

SAM 06.11.16 (200)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/11/21  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 9/26/2006 2:43:18 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 28732

Part Number: D2438

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/11/20

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 178

PC 4/4/20 (JJD)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(JJD) 06/11/21

Job Completion



W 06/11.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

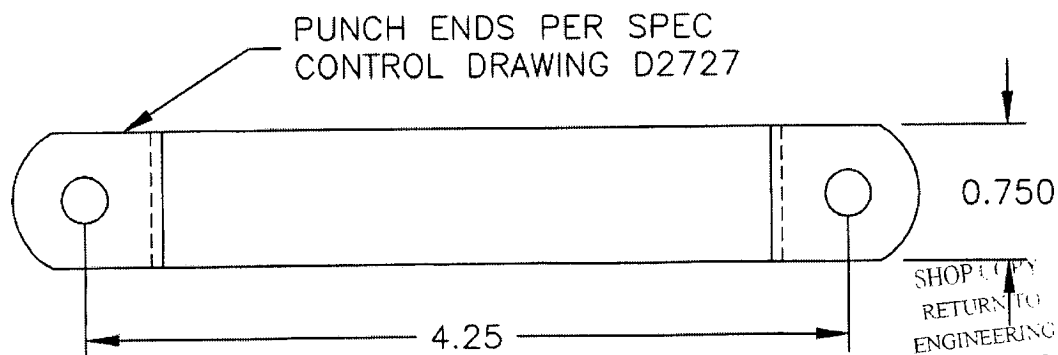
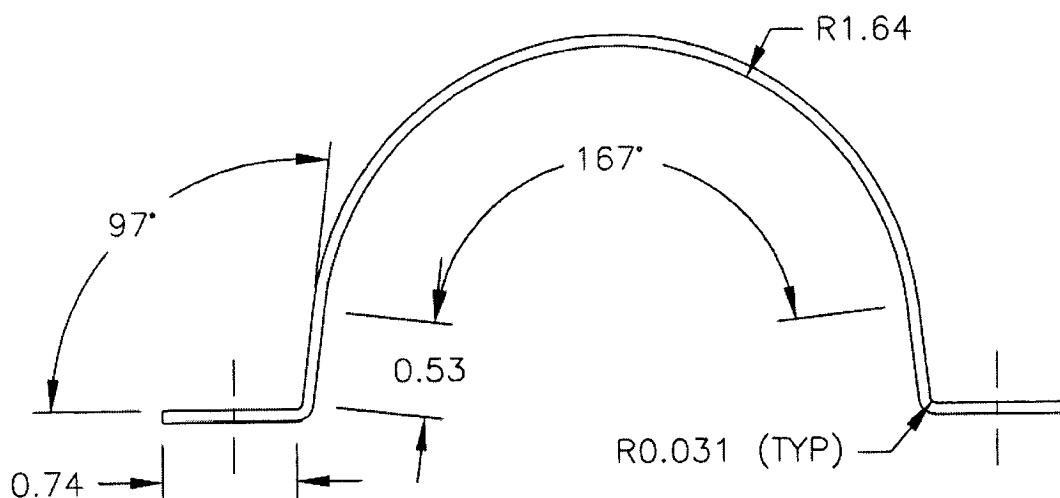
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MA</i>	APPROVED <i>MA</i>	DRAWING NO. D2438	REV. C SHEET 1 OF 1
DATE 98.05.12		TITLE CLAMP	SCALE 1:1
A	96.01.24	NEW ISSUE	
B	96.05.13	CHANGE LENGTH	
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY	

RELEASED  
44.06.17 KE



FLAT LENGTH: 7.586 END-END  
6.786 HOLE-HOLE

MATERIAL: AISI 304/316 SS 0.063 THICK

MINIMUM REQUIREMENT IS ANNEALED CONDITION

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 28132

# 00.06.06  
CP 00.06.07

**CERTIFICATE OF COMPLIANCE  
CERTIFICAT DE CONFORMITE**



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE  
POINTE CLAIRE, QC  
H9R 1A1

**DART AEROSPACE LTD**  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO.	8	OUR JOB NO	J0149639	SHIPPING MEMO	0349704	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
-	200 PCS	PO00002135	D2438B	C	CLAMP	C
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
S.S.T 304		SAMUEL SPECIALTY		P.O # 0060722 ATT'D		

	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	CONFORMS
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE **09 NOVEMBER 2006**

G.F.I. Q.C. REP.

*Robert H. Smith*





**Sigma Metals Inc.**  
45 Jeffery Blvd.  
Deer Park, NY 11729  
A Small Woman Owned Business

(631) 243-2100 - (800) 472-7890 - Fax: (631) 243-3426

1-800-610-5500

# Packing Slip

DATE: INVOICE NO:

8/8/2006

40306

## BILL TO

GFI INC.  
180 AVENUE LABROSSE  
POINT-CLAIRE  
QUE, CANADA  
H9R 1A1

## SHIP TO

GFI INC.  
180 AVENUE LABROSSE  
POINT-CLAIRE  
QUE, CANADA  
H9R 1A1

P.O. NO.	TERMS	REP	SHIP VIA	FOB	SALES ORDER
0060722	Net 30	ETF	YELLOW	DEER PARK, NY	54304

ITEM	DESCRIPTION	QTY
SS T304	304 ANN STAINLESS SHEET AMS 5513 .063 X 48" X 96 MIKES .058 81 LBS. MILL: NAS LOT# 96V7 TS 06348X964A	1
SKID	SKID CHARGES	

GFI INC.

MATERIEL REÇU NE SERA ACCEPTÉ  
APRÈS VÉRIFICATION DE DIMENSIONS,  
ÉPAISSEUR, POIDS ET CONDITIONS.

SIGNATURE Gregory Saladino DATE 11 AUG 06

### CERTIFICATE OF COMPLIANCE

THE WILLFUL RECORDING OF FALSE, FICTITIOUS OR FRAUDULENT STATEMENTS ON THIS DOCUMENT MAY RESULT IN PUNISHMENT AS A FELONY UNDER FEDERAL STATUTES. THIS DOCUMENT CERTIFIES THAT ALL ITEMS NOTED ABOVE ARE IN CONFORMANCE WITH THE CONTRACT DRAWINGS, SPECIFICATIONS AND OTHER DOCUMENTATION. ALL REQUIRED PROCESS CERTIFICATION AND CHEMICAL AND PHYSICAL TEST REPORTS ARE ON FILE IN THE FACILITY AND ARE SUBJECT TO REVIEW.

THIS MATERIAL MEETS ALL SPECIFICATIONS LISTED.

GREG SALADINO, QC

Gregory Saladino  
Quality Control Manager

ORDER COMPLETE... TEST REPORTS WITH SHIPMENT.  
WE NOW ACCEPT VISA, MASTERCARD, AND AMERICAN EXPRESS

Certificate: 312800 02

Date: 5/16/2006 Page: 1

Steel: 304

Finish: 2B

Corrosion: ASTM A262/02aE, 189Bend-OK

NAS Order: AN 0341875 01

**PRODUCT DESCRIPTION:**

STAINLESS STEEL COIL, COLD ROLLED, ANNEALED AND PICKLED.  
ASTMA240/05a, 480/05, 666/03, ASME SA240/04-A05, 480/04-A05, SA666/04  
QQS766D-A X MG PRM, AMS5513H X MRK&FIN, MIL5059D, AMD3, X CRWN MEAS

**REMARKS:**

Material free from mercury contamination. No weld repairs.  
EN 10204 3.1 PED 97/23/EC Annex1, Para. 4.3 QQS763F Cond A  
Material is RoHS-Compliant  
Product mfg. by a quality mgt. sys. in conf. w/ISO 9001:2000  
Melted & Manufactured in the USA  
Minimum solution anneal 1950 F., Water Quenched below 800 F

Product ID #	Coil #	Thickness	Width	Weight	-----Length-----	Mark	Pieces
0196V7 BAB	* 0196V7 BAB	.0600	48.0000	19,700 COIL	2087.0	11	1

**CHEMICAL ANALYSIS** CM(Country of Melt) ES(Spain) US(United States)

Heat	CM	C	CO	CR	CU	MN	MO	N	NI	P	S	SI
96V7	US	.050	.204	18.298	.361	1.728	.282	.037	8.178	.030	< .001	.277

**MECHANICAL PROPERTIES**

Product ID #	Coil #	Id o i c r	UTS KSI	.2% YS KSI	ELONG %-2"	Hard RB	Tail Hard	A 262 Pr A
0196V7 BAB	0196V7	F T	97.96	48.59	53.04	86.00	83.50	OK

**SIGMA METALS INC.**

THESE TEST REPORTS APPLY TO:

**GFI**  
P.O. **0060722**  
S/O **54304**  
PCS. **1** FTG  
NET **81#** DATE **5.8.06**

QC ENGINEER

ERIC HESS

5/16/2006